

Work Order ID 152852

Tuesday, November 08, 2016 8:26:20 AM

152852

Page 1

Item ID: D3214-1

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Decal

Start Date: 10/25/2016 Start Qty: 6.00

6

Cust Item ID:

Required Date: 11/7/2016 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals:

Process Plan:

DAS
21
9-89

Date: NOV 08 2016

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D3214

Rev C

100

0.00

100

SHEAR

Waterjet

Memo

0.06

FLOW CNC Waterjet

CUT AS PER DWG

DWG REV: CPROG REV: C

DEBURR

⑧

see 11/11/10

110

0.00

110

QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.01

Quality Control

⑧

see 11/11/10

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor Approval Verification		
			QC / QA Coordinator Approval		
Root Cause			FAULT CATEGORY		
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : _____					

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6

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6

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

NR1

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
112	QC8- Inspect parts - second check	0.00							
112									
QC	Memo	0.02				<u>8</u>			DAS 38 8-89
Quality Control									NOV 11 2016
120	Chemical Conversion Coat per QSI005 4.1	0.00							
120									
HandFinish	Memo	0.03				(X8)			2016/11/14
Hand Finishing									BEB.
130	Black Sandtex(Ref:4.3.5.7) per QSI005 4.3	0.00							
130									
Powdercoat	Memo	0.01				<u>8</u>	<u>6</u>	<u>16-11-18</u>	DAS 34 9-89
Powder Coating	START TIME: <u>7:45</u>								
	OVEN TEMPERATURE: <u>320</u>								
	FINISH TIME: <u>8:15</u>								

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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Root Cause		FAULT CATEGORY			
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐
Past Expiry Date ☐	Manufacturing Process ☐				
Misidentified ☐	Past Due ☐	OTHER : _____			

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N900040100Setup Start ***NS1***Stop ***NS2***

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6

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Run Start ***NR1***Stop ***NR2***

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

140

QC3- Inspect Part Finish

0.00

140

QC

Memo

0.01

Quality Control

NOV 17 2016

150

Small Fab

0.00

150

HAAS 1

Memo

0.18

HAAS CNC vertical machine #1

Engrave text as per Folio FA394 and Dwg D3214

DAS
49
9-89

16/12/05

160

QC2- Inspect parts off machine FAI/FAIB

0.00

160

QC

Memo

0.01

Quality Control

DAS
49
9-89

16/12/05

DQA: _____ Date: _____



QA Closed: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table border="0"> <tr> <td>Skid-tube ☐</td> <td>Cross tube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Root Cause <table border="0"> <tr> <td>Environment ☐</td> <td>No Re-verification ☐</td> </tr> <tr> <td>Design ☐</td> <td>Operator ☐</td> </tr> <tr> <td>Doc/Data ☐</td> <td>Offset/Setup ☐</td> </tr> <tr> <td>Equip/Tooling ☐</td> <td>Supplier ☐</td> </tr> <tr> <td>Handling/Pre ☐</td> <td>Training ☐</td> </tr> <tr> <td>Material ☐</td> <td>Use for Testing ☐</td> </tr> <tr> <td>Internal Transport ☐</td> <td>Poor Information ☐</td> </tr> <tr> <td>Tribal Knowledge ☐</td> <td>Rushing ☐</td> </tr> <tr> <td>LOA ☐</td> <td>Product Improvement ☐</td> </tr> <tr> <td>Substation ☐</td> <td>Process Improvement ☐</td> </tr> <tr> <td>Past Expiry Date ☐</td> <td>Manufacturing Process ☐</td> </tr> <tr> <td>Misidentified ☐</td> <td></td> </tr> </table>		Environment ☐	No Re-verification ☐	Design ☐	Operator ☐	Doc/Data ☐	Offset/Setup ☐	Equip/Tooling ☐	Supplier ☐	Handling/Pre ☐	Training ☐	Material ☐	Use for Testing ☐	Internal Transport ☐	Poor Information ☐	Tribal Knowledge ☐	Rushing ☐	LOA ☐	Product Improvement ☐	Substation ☐	Process Improvement ☐	Past Expiry Date ☐	Manufacturing Process ☐	Misidentified ☐		<table border="0"> <tr> <td>Pressure/Forced ☐</td> <td>Temperature/Cure ☐</td> </tr> <tr> <td>Bending ☐</td> <td>Set-up ☐</td> </tr> <tr> <td>Centre Not Concentric ☐</td> <td>BOM/Route ☐</td> </tr> <tr> <td>Cracks ☐</td> <td>Broken/Damage/Defect ☐</td> </tr> <tr> <td>Crimp/Kink/Ripple/Wave ☐</td> <td>Inspection Incomplete/Unqualified ☐</td> </tr> <tr> <td>Cuffs ☐</td> <td>Contamination ☐</td> </tr> <tr> <td>Crushing ☐</td> <td>Countersink ☐</td> </tr> <tr> <td>Heat Treat ☐</td> <td>Cut Too Short ☐</td> </tr> <tr> <td>Wave/Twist in Tube ☐</td> <td>Instructions Incomplete/Unclear ☐</td> </tr> <tr> <td>Marks/Chatter ☐</td> <td>Drill Holes ☐</td> </tr> </table>	Pressure/Forced ☐	Temperature/Cure ☐	Bending ☐	Set-up ☐	Centre Not Concentric ☐	BOM/Route ☐	Cracks ☐	Broken/Damage/Defect ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Cuffs ☐	Contamination ☐	Crushing ☐	Countersink ☐	Heat Treat ☐	Cut Too Short ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Marks/Chatter ☐	Drill Holes ☐	FAULT CATEGORY <table border="0"> <tr> <td>Power Loss/Surge ☐</td> <td>Positioned Wrong ☐</td> </tr> <tr> <td>Folio/Program ☐</td> <td>Outside Dimensions ☐</td> </tr> <tr> <td>Grain ☐</td> <td>Over/Under tolerance ☐</td> </tr> <tr> <td>Weld ☐</td> <td>Part Incorrect ☐</td> </tr> <tr> <td>Wrong Stock Pulled ☐</td> <td>Part Lost/Missing ☐</td> </tr> <tr> <td>Out of Sequence ☐</td> <td>Part Moved ☐</td> </tr> <tr> <td>Off-set ☐</td> <td>Drawing ☐</td> </tr> <tr> <td>Mislabeled ☐</td> <td>Finish ☐</td> </tr> <tr> <td>Fit/Function ☐</td> <td>Misread ☐</td> </tr> <tr> <td>Misaligned/off center ☐</td> <td>Turning Sequence ☐</td> </tr> </table>	Power Loss/Surge ☐	Positioned Wrong ☐	Folio/Program ☐	Outside Dimensions ☐	Grain ☐	Over/Under tolerance ☐	Weld ☐	Part Incorrect ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Out of Sequence ☐	Part Moved ☐	Off-set ☐	Drawing ☐	Mislabeled ☐	Finish ☐	Fit/Function ☐	Misread ☐	Misaligned/off center ☐	Turning Sequence ☐
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152852

Page 4

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N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Decal

Start Date: 10/25/2016 Start Qty: 6.00

6

Cust Item ID:

Required Date: 11/7/2016 Req'd Qty: 6.00

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Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

Identify as per dwg & Stock Location: *Stock*

0.00

180

Packaging

Memo

0.01

Packaging

6 **DEC 05 2016** **DAS 6 89**

190

QC21- Final Inspection - Work Order Release

0.00

190

QC

Memo

0.10

Quality Control

16/12/6 *MF* *16-12-06*

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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Picklist Print

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Page 1

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152852

Parent Item: D3214-1

D3214-1

Parent Item Name: Decal

Start Date: 10/25/2016

Required Date: 11/7/2016

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP A04.04.15New issueKJ/RF
IPP Rev:B Now 6061-T6 06-06-23 JLM IPP REV
C:NOW ON WATERJET 13-02-08 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.080		Purchased		No		110	sf	118.3400	0.0743	0.469263			

M6061T6S 080

6061-T6 .080 Sheet

Dec 16/11/10

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
MAT020	118.34	
134217	9.1	
m132772	4.3	
m133587	7.7	
m133828	2.6	
m134551	7	
m134830	19.9	
m135147	18.07	
m135559	12.87	
m135861	36.8	

DQA: _____ Date: _____



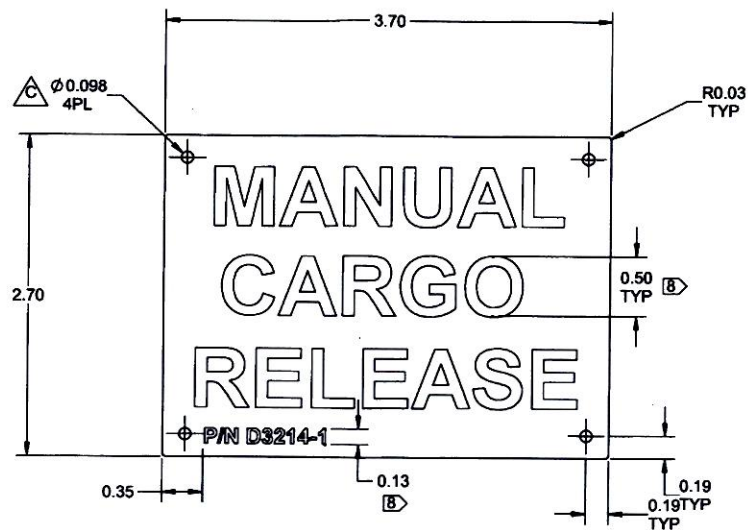
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Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____			
Misidentified ☐	Past Due ☐				



D3214-1 PLACARD

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WITHOUT NOTICE
WORK ORDER

NO. 152852 MW
16-11-08

RELEASED
2013-02-07
ND

NOTES:

- 1) MATERIAL: 6061-T6 (PER QQ-A-250/11 OR AMS 4025 OR AMS 4027), 0.080 THICK
REF DART SPEC M061T6S.0.08 OR
5052-H32/H34 (PER QQ-A-250/8 OR AMS 4016), 0.080 THICK
REF DART SPEC M5052H32S.0.080
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "BLACK SANDEX" (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES: N/A
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: LESS THAN 0.010 lbs
- 8) ENGRAVE ALL LETTERS TO A DEPTH OF 0.005 USING A TOOL RADIUS OF 0.039 AFTER POWDER COAT.

C	FORMAT TO CURRENT STDS, 3 HOLES ADDED; $\phi 0.098$ 4PL WAS 1PL. REF PART2-186	SFM	13.01.15
B	ADD 6061-T6 MATERIAL	CB	08.05.29
A	NEW ISSUE	CB	04.01.27
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3214 TITLE PLACARD SHEET 1 OF 1 SCALE NTS COPYRIGHT © 2004 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DRAWN	SFM		
CHECKED	AS		
MFG. APPR.	Y/S		
APPROVED	Y/S		
DE APPR.	Y/S		
DATE	13.01.15		